

Work Order ID 147762

June 13, 2016 1:09:03 PM

147762

Ship July 8

Page 1

Item ID: D4019-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Light Lid Short Basket Assembly
 Start Date: 6/27/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/8/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: SW Date: 6/13/16 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4019	F

100 Weld per dwg A/R Aluminum rod Batch: B134926

100

Large Fab

Large Fab

Memo

0.33

1- Assemble ribs , weld as per dwg D4019 using DT9606B. When welding D4019-3, weld top and bottom then make a small hole in the weld to let air out. Then weld remaining sides of D4019-3 Rib. Let it cool down, then block holes with weld.

****DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID FRAME****

2- weld hinge, label plate and Mounting plates as per dwg D4019

110

110

QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds 0.00

Memo

0.00

DAS
24
9-00

JUN 28 2016

(Signature)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval				
Description Work Order Deviation				Disposition				Completed By			
								Lead hand / Supervisor Approval Verification			
								QC / QA Coordinator Approval			
Root Cause				FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : ☐											

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120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<i>ix</i>	24 9-00		JUN 28 2016
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo ***ENSURE TO RINSE CAREFULLY ACID AND ALODINE***	0.00 0.11				<i>ix</i>	<i>Cy</i>		16-06-28
140 *140* Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: <i>B134102</i> Memo 1- weld (4) corners	0.00 0.03				<i>ix</i>	<i>CC</i>		16-6-28

DQA: _____ Date: _____

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
150									
QC	Memo	0.00							
Quality Control									

160	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
160									
Powdercoat	Memo	0.03							
Powder Coating	1- touch up corner with alodine only 2- Plug holes prior to and mask sides of hinge prior to powdercoat								

1ST COAT: 11:45.
 START TIME: 11:45.
 OVEN TEMPERATURE: 300°
 FINISH TIME: 12:15.
 ***** 2nd coat if necessary *****
 2ND COAT:
 START TIME: _____
 OVEN TEMPERATURE: _____
 FINISH TIME: _____

JUN 28 2016
 1 16-06-29 22:22

DQA: _____ Date: _____



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170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	Assemble as per dwg	0.00							
180									
HandFinish	Memo	0.13							
Hand Finishing	Install webbing as per dwg and label								
190	QC5- Inspect part completeness to step on W/O	0.00							
190									
QC	Memo	0.00							
Quality Control									

68-6
91
SVO

DAS
38
9-89

JUN 30 2016

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200	Identify as per dwg & Stock Location: <u>W10</u>	0.00							
200									
Packaging	Memo	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.02							
Quality Control									

D4032-043 / B 147762 1c f W 10/06/16

10/7/14

GA 6/30/16

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Picklist Print

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Parent Item: D4019-041

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Required Date: 7/8/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.12.07 verified by:EC IPP Rev:B as per dwg revA 10.03.15 verified by:EC IPP Rev:C as per dwg revC DD 10.04.20 verified by:EC IPP Rev:D as per dwg revD DD 10.08.18 verified by:EC IPP Rev:E 13.07.08 as per dwg rev.E DD verf:JLM IPP REV:F 13.08.21 DWG REV.F / ECN 13-624 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4019-1		Manufactured	No			100	Each	0.0000	2	2			
D4019-1						B148135			2x			16-6-28	
Rib													
D4019-3		Manufactured	No			100	Each	6.0000	2	2			
D4019-3									**			16-6-28	
Rib													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA004		6							
				144402		6							
D4016-5		Manufactured	No			100	Each	16.0000	3	3			
D4016-5									**			1602 8 2 N07	
Hinge Half, Light Lid													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA004		16							
				137225		16							
D2957		Manufactured	No			100	Each	45.0000	4	4			
D2957									**			JUN 28 2016	
Mounting Plate													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA004		45							
				137718		15							
				138993		30							

Picklist Print

June 13, 2016 1:09:12 PM

Page 2

Work Order ID: 147762

147762

Parent Item: D4019-041

D4019-041

Parent Item Name: Light Lid Short Basket Assembly

Start Date: 6/27/2016

Required Date: 7/8/2016

Start Qty: 1.00

Required Qty: 1.00

✓ D4035-047
D4035-047
Lid Rib Assembly, Aft (Light)

Manufactured No

100 Each 4.0000 2 2

**

CC JUN 28 2016

Location

Loc Qty

Loc Code

WA004

4

144403

4

D4029-043

Manufactured No

180 Each 1.0000 1 1

**

D4029-043
Webbing (Short Basket)

Location

Loc Qty

Loc Code

t498a

1

127211

1

D4056-1

Manufactured No

100 Each 11.0000 1 1

**

✓ ***D4056-1***
Label Plate

Location

Loc Qty

Loc Code

WA004

11

120216

11

MS20600-AD4W4

Purchased No

180 Each 2,024.000 30 30

**

MS20600-AD4W4
Rivets

Location

Loc Qty

Loc Code

CCK005

1982

M133990

1482

M134955

500

ST308

42

M132640

42

72

18

DAS 6 9:39

JUN 28 2016

134467

132

DAS 6 9:39

JUN 29 2016

Picklist Print

June 13, 2016 1:09:12 PM

Page 3

Work Order ID: 147762

147762

Parent Item: D4019-041

D4019-041

Parent Item Name: Light Lid Short Basket Assembly

Start Date: 6/27/2016

Required Date: 7/8/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149DN949J

Purchased

No

180

Each

208.0000

30

30

NAS1149DN949J

DAS

6

Washer

9-89

Location

Loc Qty

Loc Code

ST265

208

m133483

8

m134567

200

D2728-1

Manufactured

Yes

180

Each

-5.0000

1

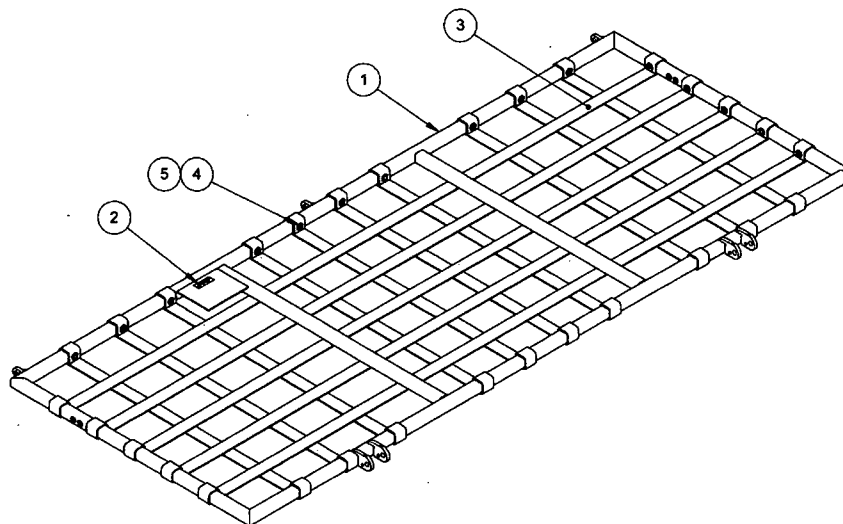
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D2728-1

Dart Logo Label Small

01 11 16/02/03

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4019-041	LIGHT LID SHORT BASKET ASSY
1	1	D4019-101	BASKET LID WELDMENT ASSY
2	1	D2728-1	DART LOGO LABEL
3	1	D4029-043	WEBBING (SHORT BASKET)
4	30	MS20600AD4W4	RIVET, BLIND, PAN-HEAD
5	30	NAS1149DN949J	WASHER

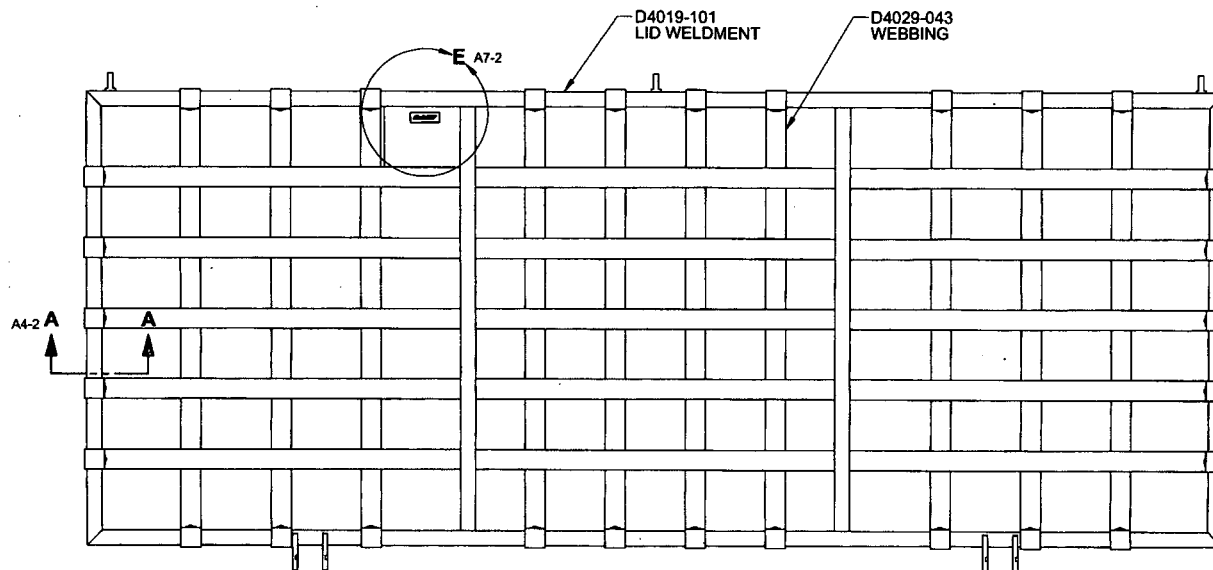


D4019-041 LIGHT LID SHORT BASKET ASSY

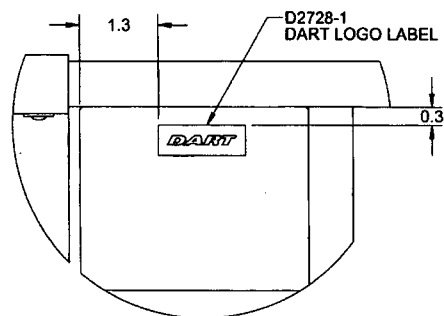
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 4.82 lbs

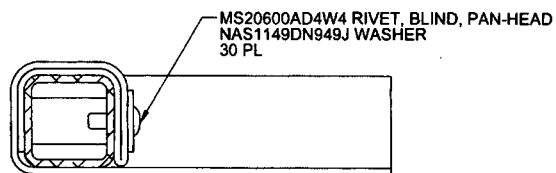
F	CB-3 D4035-047 WAS D4035-045 (REASON PROFORM OPTION REMOVED)	AJS	13.07.18
E	MS20600AD4W4 WAS MS20600AD4W3; NAS1149DN949J WAS NAS1149DN416J (ZN D6-1, C6-1, B3-2) REASON: PART13-258.	MB	13.06.19
D	REORGANIZED BILL OF MATERIALS: SEPARATED -101 FROM -041 (D6-1, D6-3); REORGANIZED VIEWS ON SHT 3 ACCORDINGLY; REMOVED D4086-243, UPDATED VIEW E ACCORDINGLY (A7-2); REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
C	MS20600AD4W3 WAS MS20600AD4W5: BOM & (B3-2)	JPH	10.04.08
B	BOM: INSERTED QTY 1 D2728-1 AS ITEM 4 & QTY 1 D4086-243 PLACARD AS ITEM 11; ITEMS RENUMBERED AS REQD; DETAIL E ADDED (A7-2) & (D5-2); SECTION B-B REV'D (D6-3) DIM ADDED (B4-3); WELD SYMBOL REVISED (D5-3)	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D4019	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LIGHT LID SHORT BASKET	NTS
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D4019-041 LIGHT LID SHORT BASKET ASSY



DETAIL E D5-2

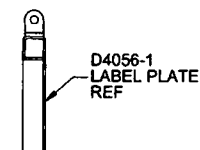


SECTION A-A C7-2

RELEASED
2013-08-16

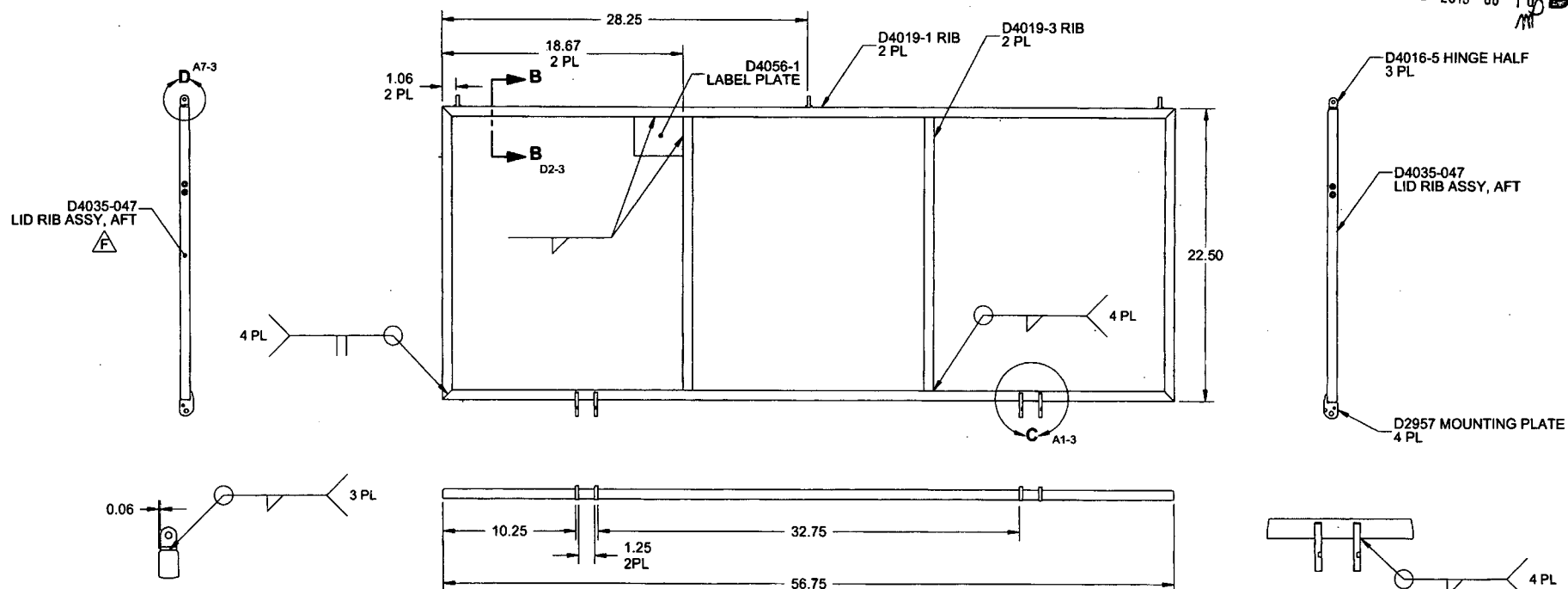
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	41	DRAWING NO.	REV. F
MFG. APPR.		D4019	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LIGHT LID SHORT BASKET	NTS
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D4019-101	BASKET LID WELDMENT ASSY
1	4	D2957	MOUNTING PLATE
2	3	D4016-5	HINGE HALF, LIGHT LID
3	2	D4019-1	RIB
4	2	D4019-3	RIB
5	2	D4035-047	BASKET LID RIB ASSY, AFT (LIGHT)
6	1	D4056-1	LABEL PLATE, 350 LIGHT BASKET



SECTION B-B C6-3

RELEASED
2013-08-16



DETAIL D C7-3

D4019-101 BASKET LID WELDMENT ASSY

DETAIL C B3-3

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 3.26 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	41	DRAWING NO.	REV. F
MFG. APPR.		D4019	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LIGHT LID SHORT BASKET	NTS
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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